

Date: Tuesday, 20/01/2009 9:09:26 AM
 User: Melanie Fauteux

Process Sheet

RUSH

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM GUIDE
Job Number	: 44942		
Estimate Number	: 12657		
P.O. Number	:	Part Number	: D35893
This Issue	: 20/01/2009 S.O. No. :	Drawing Number	: D3589 REV B PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B PRELIM
Previous Run	: 44733	Material	:
Written By	:	Due Date	: 21/01/2009 Qty: 8 Um: Each
Checked & Approved By	: <u>MF-09-01-20</u>		
Comment	: Est Rev:A 08-05-29 new issue DD verified by:EC		



Additional Product

PRELIMINARY ISSUE

Job Number:



109.020 for 09-01-20

Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0750 0500	304 SS Roundbar .750
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9-01-20



Comment: Qty.: 0.0569 f(s)/Unit Total: 0.4553 f(s)

8.500"

304 SS Roundbar

batch: M108415

09/01/20

8 pos

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA754 & DWG D3589

FOLIO REV: _____

DWG REV: B Prelim.

2-DEBURR AS REQUIRED

09/01/20

8 pos

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/01/20

8 pos

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ENGINEERING APPROVAL

109.020

8x

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5-120

MF 09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 20/01/2009 9:09:26 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM GUIDE

Job Number: 44942

Part Number: D35893

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09.06.20 AUTH LL

RELEASED 5 DATE 04.02.17

MF 09-01-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

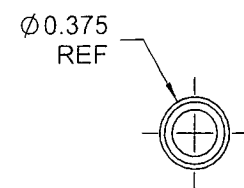
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

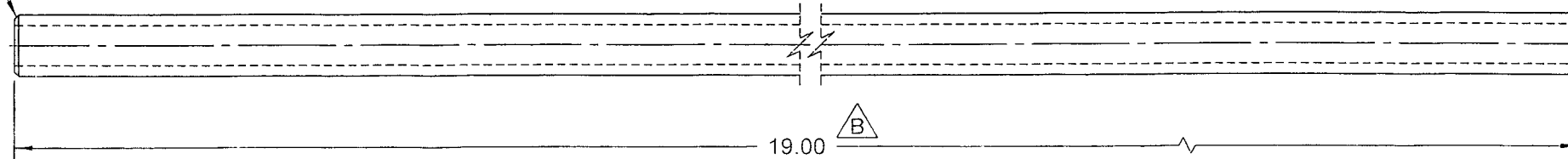
NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

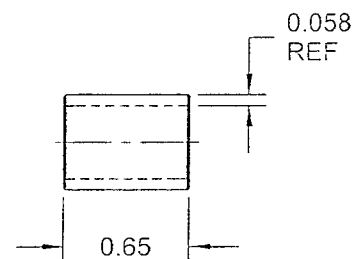
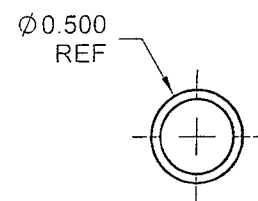


0.03 X 45°
CHAMFER
2 PL

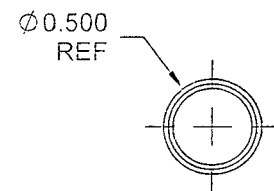


0.065
REF

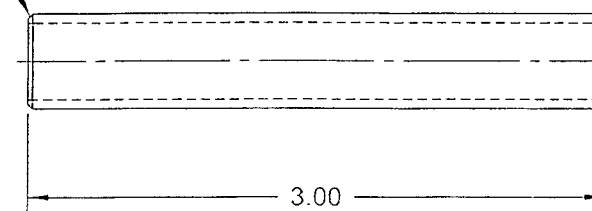
D3589-1 ARM



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



0.049
REF

D3589-5 LATCH GUIDE

D3589-1/-3/-5 NOTES:

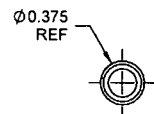
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

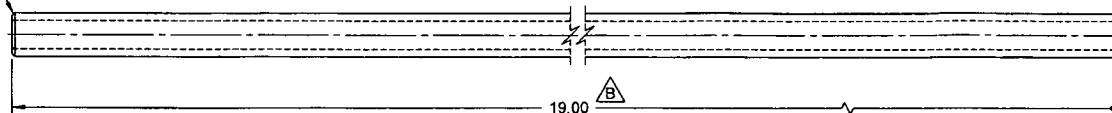
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

44942

08.01.19 PER
ECN #09-5029
FOR RH LATCH

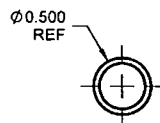


0.03 X 45°
CHAMFER
2 PL

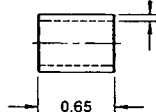


0.065
REF

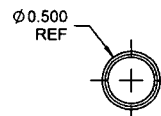
D3589-1 ARM



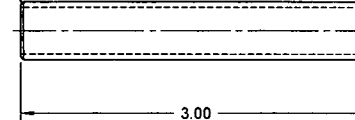
0.058
REF



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



0.049
REF

D3589-5 LATCH GUIDE

D3589-1/-3/-5 NOTES:

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D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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